

Step July 4

D 2 3 6 2 - 3

Work Order ID 103257

June-20-13 9:14:05 AM

103257

B 1 0 3 2 5 7

Page 1

R E V E 4

Item ID: D2362-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Step Support Bracket

Stop

NS2

Start Date: 6/20/13 Start Qty: 15.00

15

Cust Item ID:

Required Date: 7/02/13 Req'd Qty: 15.00

15

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

NR1

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2362	Rev E1

100 *100* HAAS CNC VERTICAL MACHINING #1
 HAAS I Memo 0.00
 HAAS CNC vertical machine #1 1- Mill as per Folio FA800 Rev: AA & Dwg D2362 Rev: E 2-Deburr
 per dwg D2362

110 *110* QC2- Inspect parts off machine FAI/FAIB 0.00
 QC Memo 0.00
 Quality Control

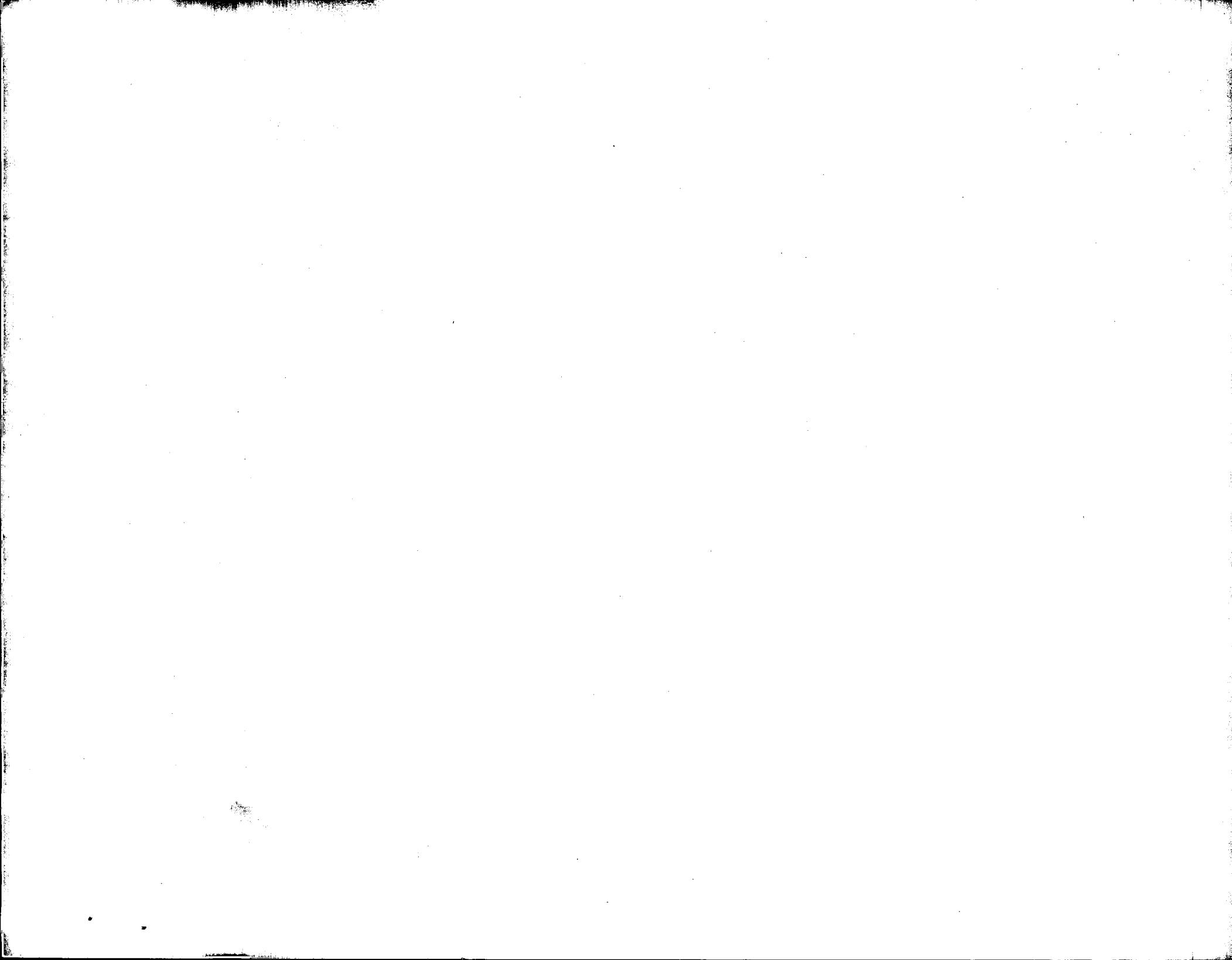
120 *120* QC8- Inspect parts - second check 0.00
 QC Memo 0.00
 Quality Control

2/13/06/24

15 6

SL13-6-22

SL13-6-22



Work Order ID 103257

June-20-13 9:14:05 AM

103257

Page 2

Item ID: D2362-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Step Support Bracket

Start Date: 6/20/13 Start Qty: 15.00

15

Cust Item ID:

Required Date: 7/02/13 Req'd Qty: 15.00

15

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Small Fab

0.00

15

8

SL 13-6-22

Small Fab

Memo

0.00

Small Fab

Deburr

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

15x 8 m/f 13/06/27

140

Powdercoat

Powder Coating

Memo

0.00

START TIME:

11:00

OVEN TEMPERATURE:

300°F

11:30

150

QC3- Inspect Part Finish

0.00

15x - d 14/06/22

150

QC

Quality Control

Memo

0.00

Work Order ID 103257

103257

Page 3

June-20-13 9:14:05 AM

Item ID: D2362-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Step Support Bracket

Start Date: 6/20/13 Start Qty: 15.00

15

Cust Item ID:

Required Date: 7/02/13 Req'd Qty: 15.00

15

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

160

160

Small Fab

Small Fab

Small Fab

170

170

QC

Quality Control

(DAS
22
08)

Memo

Bond rubber D2397-1 followed by D2397-3 using contact cement as per Dwg
D2362

0.00

0.00

0.00

AS
18/07/04

0.00

0.00

180

180

Packaging

Packaging

Identify as per dwg & Stock- Location: ST478

0.00

Memo

FF
15 φ 13-07-03

(x6)

15 13-07-05

Work Order ID 103257

103257

Page 4

June-20-13 9:14:05 AM

Item ID: D2362-3

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Step Support Bracket

Start Date: 6/20/13 Start Qty: 15.00

15

Cust Item ID:

Required Date: 7/02/13 Req'd Qty: 15.00

15

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

1Q0

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

13/7/88

ME
13-7-885

Picklist Print

June-20-13 9:14:04 AM

Page 1

Work Order ID: 103257

Parent Item: D2362-3

Parent Item Name: Step Support Bracket

Start Date: 6/20/13

Required Date: 7/02/13

Comments: IPP: G00.05.18 Added inspection level 8EC

Start Qty: 15.00

Required Qty: 15.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2265 Step Bracket		Manufactured	No			160	Each	35.0000	1	15			
-----------------------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST488	35	
44114	5	
97950	30	

5
10

ark 13/06/22

D2397-1 Rubber Cushion		Manufactured	No			160	Each	20.0000	1	15			FF 13-07-03
---------------------------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	-------------

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

GA	1	
72737	1	
ST009	19	
99483	19	

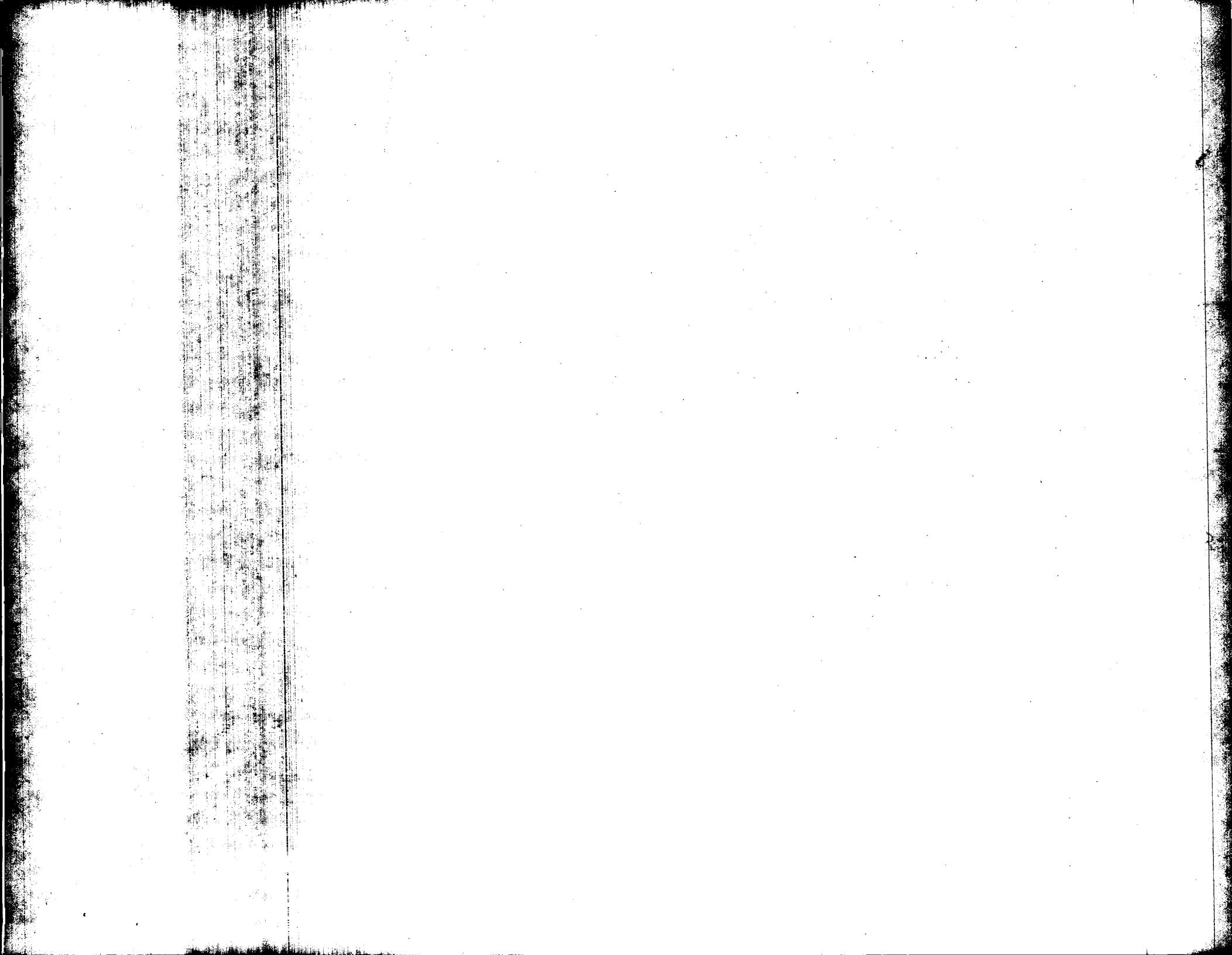
15

D2397-3 Rubber Cushion		Manufactured	No			100	Each	19.0000	1	15			FF 13-07-03
---------------------------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	-------------

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST009	19	
99484	19	

B 103 807



DART AEROSPACE LTD	Work Order:	163257
Description: Step Support Bracket	Part Number:	D2362-3
Inspection Dwg: D2362 Rev: E1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	SJ	Audited by:	owl	Prototype Approval:	N/A
Date:	13-06-22	Date:	13/06/24	Date:	N/A

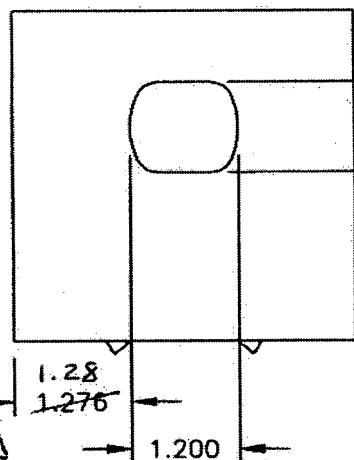
Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF	TT

EI

03.10.07

TOLERANCE CHANGE

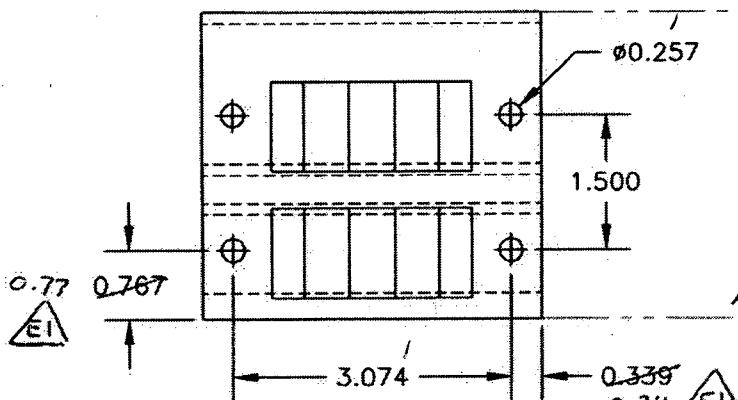
VIEW A-A



0.80 \triangle
0.800
1.000
REMOVE TIPS
FROM CASTING
MAX 0.080

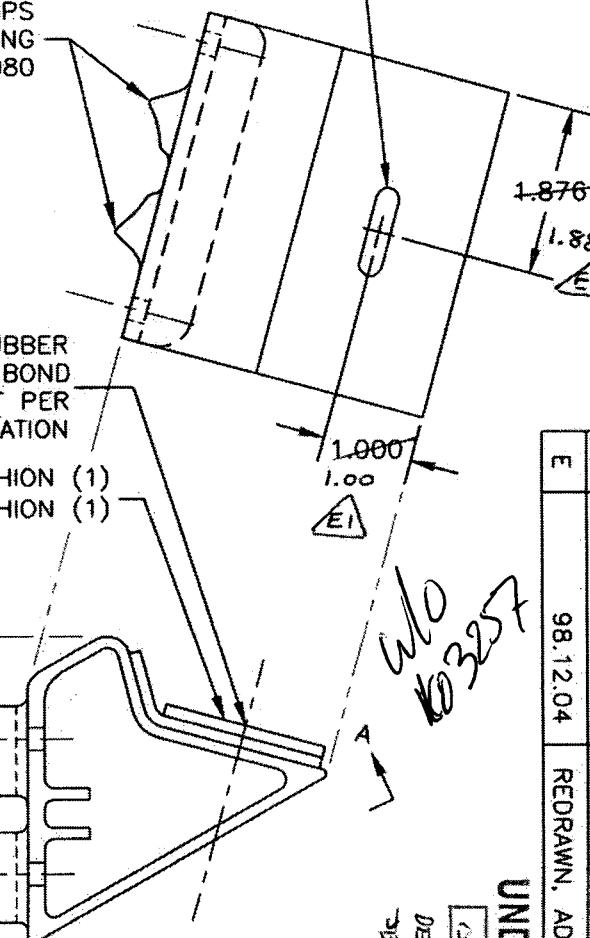
CENTER D2397-1/-3 RUBBER
HOLE WITH SLOT AND BOND
WITH CONTACT CEMENT PER
MANUFACTURER'S SPECIFICATION

D2397-1 RUBBER CUSHION (1)
D2397-3 RUBBER CUSHION (1)



D2362-3

0.257 X 0.75 SLOT



RELEASED
98.12.14 \triangle



DESIGN BW	DRAWN BY <i>JP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED \triangle	APPROVED <i>M</i>	DRAWING NO. D2352
DATE 98.12.04	STEP SUPPORT BRACKET	REV. E SHEET 1 OF 3 SCALE 1:2
A	95.02.15 NEW ISSUE	
B	95.03.22 CHANGED RUBBER TO D2397	
C	96.01.22 ADD D2362-5	
D	97.05.21 ADD D2362-7	
E	98.12.04 REDRAWN, ADD 2397-5	

UNDER REVIEW

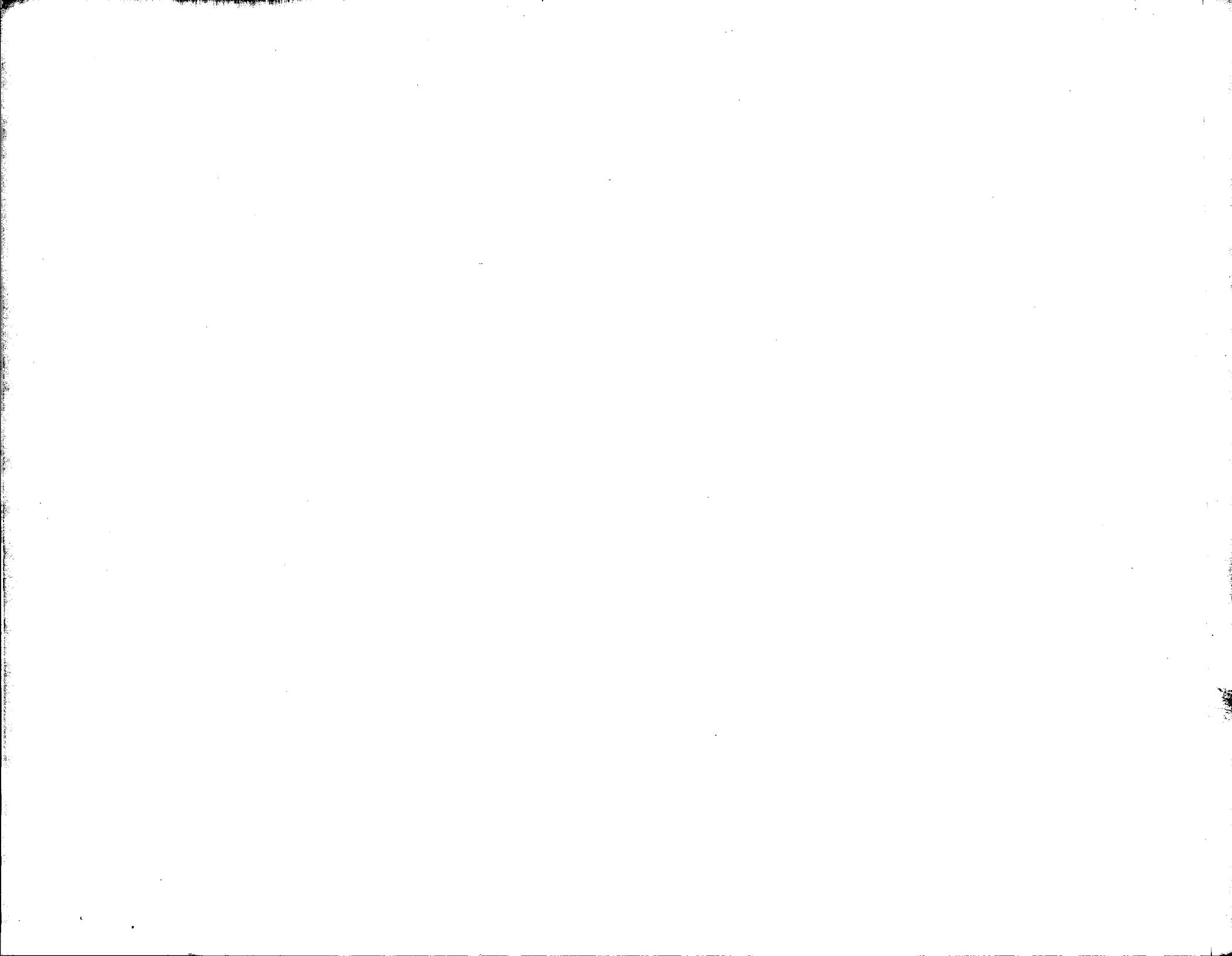
12/03/95 CP

DESIGN NOK BUT CHECK WITH
DB BEFORE MANUFACTUREOK
03.11.09NOTES:

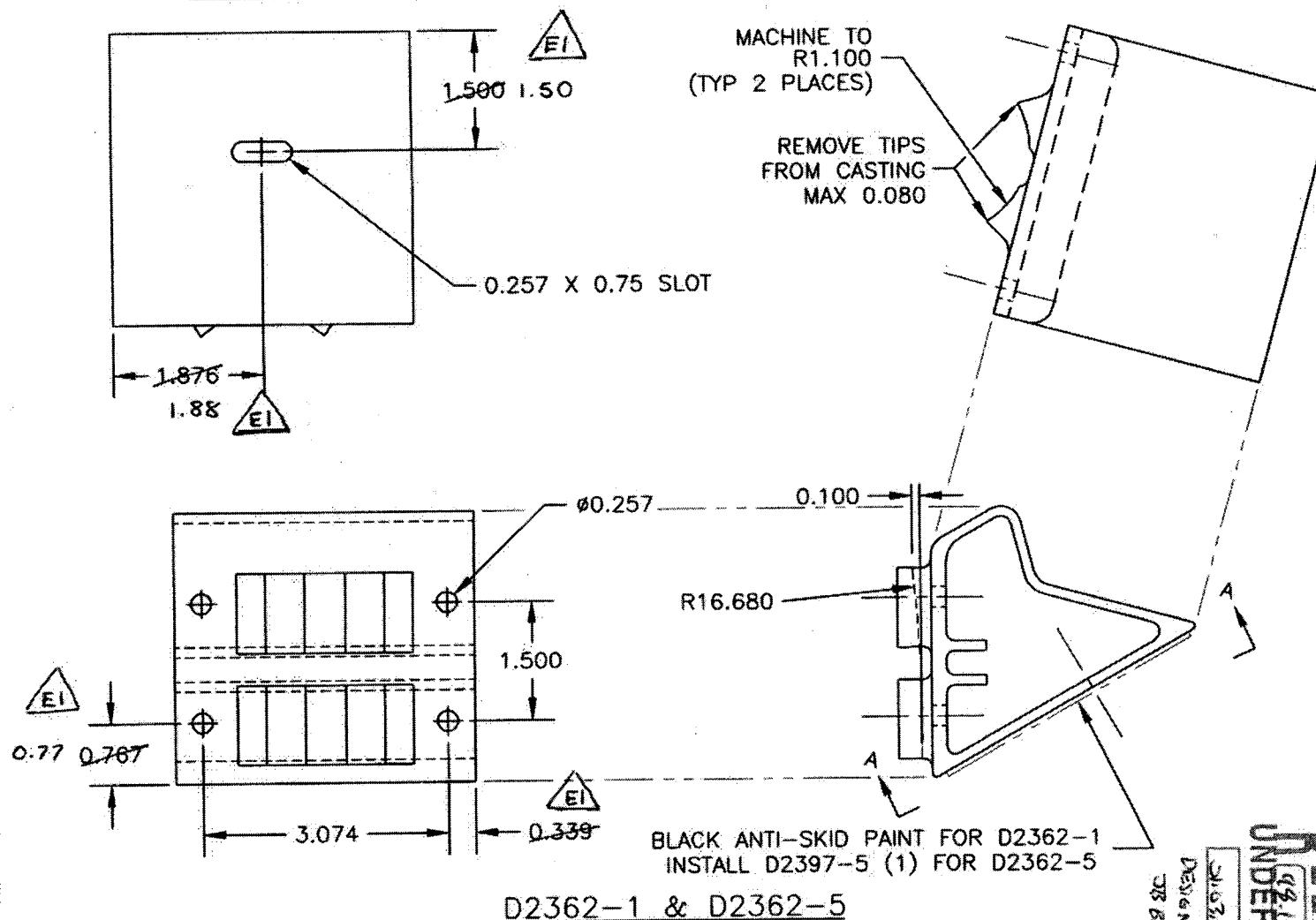
MAKE FROM D2265

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING
RUBBER IN PLACE

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



VIEW A-A



NOTES:

MAKE FROM D2265.

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

© DART 1995

DESIGN BW	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>KE</i>	APPROVED <i>MM</i>	DRAWING NO. D2362
DATE 98.12.04	TITLE STEP SUPPORT BRACKET	REV. E SHEET 2 OF 3 SCALE 1:2

RELEASED
1998-12-04
UNDER REVIEW

1998-12-05 CP

DESIGNOK, BUT CHECK W/

THE MANUFACTURE

OK
CP

D2362-041 (SHOWN)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER
QSI 005 4.3
ANTI-SKID PAINT PER QSI 005 4.4 AFTER
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)

MAKE FROM D2265 CASTING. DRILL D2265 AS
SHOWN IN D2362-041 ASSEMBLY

NOTES:

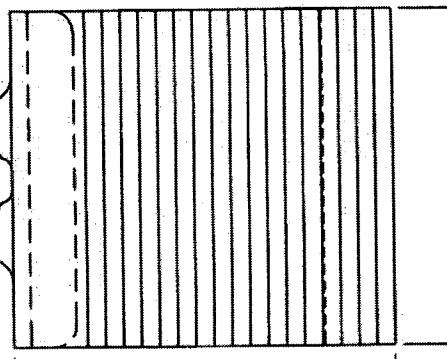
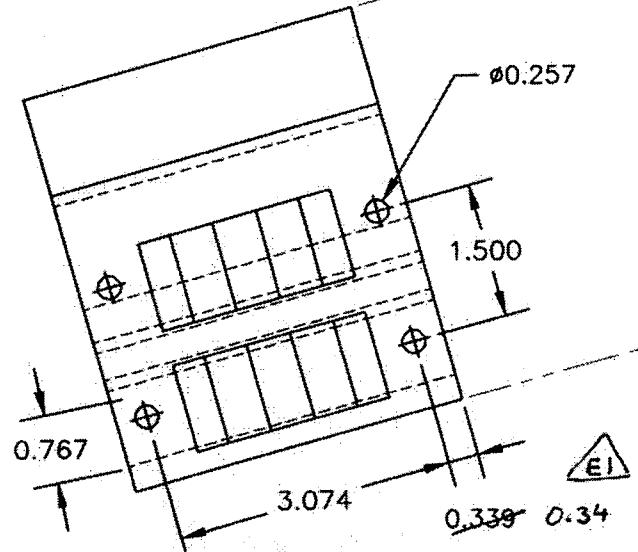
TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

REMOVE TIPS
FROM CASTING
MAX 0.080

BLACK ANTI-SKID PAINT

D2244-3.75

WELD PER DART 1/8
QSI 004



OK for now

RELEASER
49.12.14
LE

DART

© DART 1995

DESIGN BW	DRAWN BY GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEKED RE	APPROVED MM	DRAWING NO. D2362
DATE 98.12.04	STEP SUPPORT BRACKET	SHEET 3 OF 3 SCALE 1:2

